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W/O Split

DART AEROSPACE LTD		Work Order:	21383 A
Description: Bracket		Part Number:	D3145-1
Dwg: D3145 Rev. B		Qty:	109
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	04.08.23	10
2	MV	Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8) M6061T6B2.000x2.000) Batch: M16351	Sn	05/01/14	10
3	MV	Machine per Folio FA318 and Dwg D3145	BE/SD	05.01.26	9
4	QC2	Inspect parts as they come off the CNC machine	BE/SD	05.01.26	9
5	MV	Deburr and Tumble	BE	05.02.02	9
6	QC5	Second inspection	mi/BE	05.02.02	9
7	FP	Chemical Conversion Coat per QSI 005 4.1	MM	05.02.09	9
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	MM	05.02.09	9
9	QC3	Inspect work to Step 8	CL	05/02/09	9
10	ST	Identify and Stock	CL	05/02/09	9
11	AC	Cost / part 108.54	SAC	05-02-11	9
12	DC	Close W/O 114.85 Inspect Level 21	JA	0502.10	9

Rev	Date	Change	Revised By	Approved
A	03.02.28	New issue	KJ/RF	JA

RELEASED
03.03.04 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

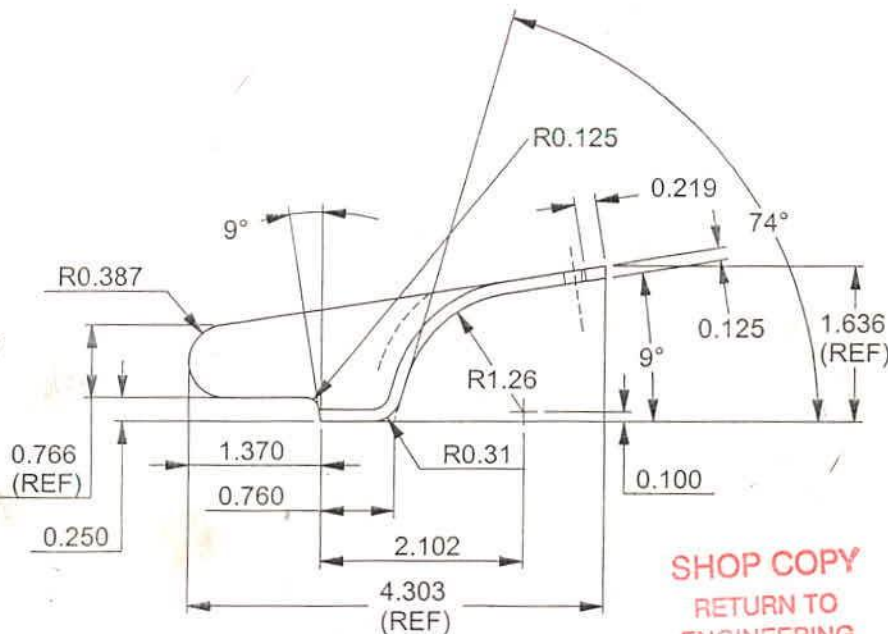
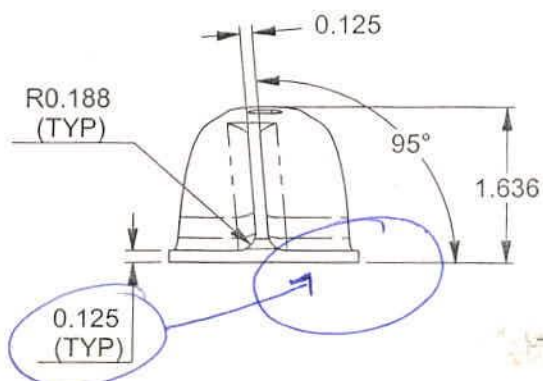
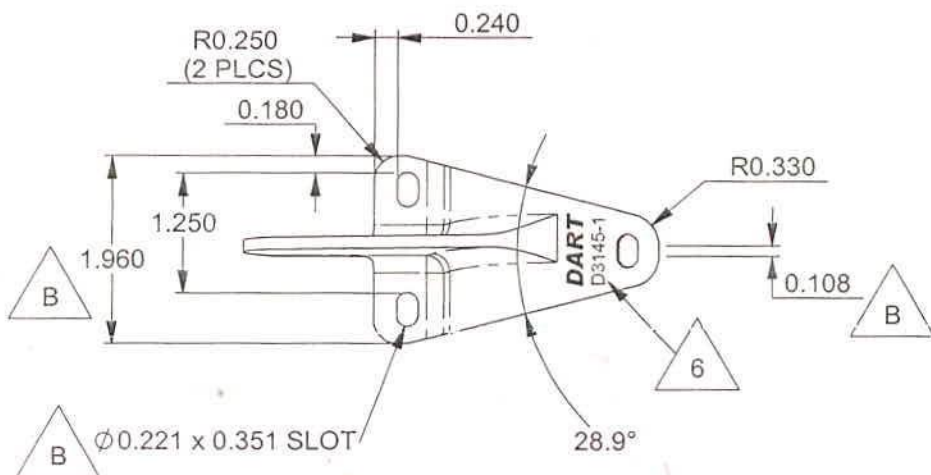
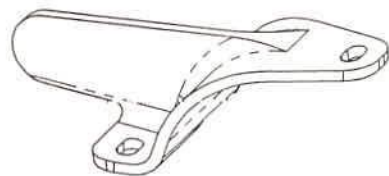
NCR 21383A		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial					
05.02.02	3	- 2 parts scrap, due to wrong cutter. (HSS instead of carbide)	<i>B</i>	destroy	<i>B</i> 05.02.02	<i>B</i> 05.02.09	<i>B</i> prosen	<i>B</i> 05.02.09
05.02.02	3	- 1 part is out tol. under by 0.010"; see attached Dwg. for specified affected area.	<i>B</i>	destroy	<i>B</i> 05.02.02	<i>B</i> 05.02.09	<i>B</i> prosen	<i>B</i> 05.02.09

PAR#: N/AFault Category: Mmuf/knc cellDQA: *B*Date: 05/02/10QA: N/C Closed: *4*Date: 05.02.10



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06	TITLE BRACKET	SCALE 1:2	
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED
03.03.12



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 21383

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 23, 2004
09:51 am

Work Order No : 0021383 **A**
Project Name : D3145-1
Project For : WK440
Work Order Type : Main
Main WO Number :
House Part Number : D3145-1
Description : Bracket
Manufactured : Yes
Amount Req'd : 10 **9**
Amount Done : 0
Start Date : 08-23-04
Est Finish Date : 09-21-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 21383
Description: BRACKET		Part Number: D3145-1
Inspection Dwg: D3145 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	±.010	0.243	✓		Vern	
0.180	±.010	0.184	✓		Vern	
RO.250	±.010	RO.250	✓		Vern R-6	
1.250	±.010	1.249	✓		Vern	
1.960	±.010	1.965	✓		Vern	
Ø0.221X351	±.010	Ø0.221X344	✓		Vern	
0.108	±.010	0.108	✓		Vern	
0.125	±.010	0.125	✓		Vern	
1.636	±.010	1.640	✓		Vern	
RO.188	±.010	RO.188	✓		Vern	
0.125	±.010	0.120	✓		Vern	
95°	±.1°	95°	✓		Protractor	
RO.387	±.010	RO.390	✓		R-6	
0.766	±.010	0.766	✓		Vern	
0.250	±.010	0.248	✓		Vern	
1.370	±.010	1.375	✓		Vern	
0.760	±.010	0.760	✓		Vern	
4.303	±.010	4.304	✓		Vern	
0.219	±.010	0.219	✓		Vern	

Measured by: <i>ML</i>	Audited by: <i>EL</i>	Prototype Approval: <i>N/A</i>
Date: 05/01/31	Date: 05.02.02	Date:
Rev: A	Change: New Issue	Revised by: KJ/JLM Approved: